

Work Order ID 130497 - 1

130497

Page 1

Friday, March 13, 2015 11:48:45 AM

Item ID: D3565-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate

Start Date: 3/13/2015 Start Qty: 8.00

8

Cust Item ID:

Required Date: 3/13/2015 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 15-03-13 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3565	Rev C								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3565 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary20 0 Jm15-3-15

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

20 0 Jm15-3-15

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

20 0 Jm15-3-15

DAG
38
9-89

MAR 17 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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Friday, March 13, 2015 11:48:45 AM

Item ID: D3565-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
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 Required Date: 3/13/2015 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Weld D3009-3 cups as per dwg D35652-Weld hard facing as per Dwg D3565 using DT8991 jig/A/R 2059B Hard Coat rod Batch: <u>11/23823</u>								
140	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									

1 Q 158-19

Q 15-05-19 PD

Q 15-05-19 PD

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WORK ORDER NON-CONFORMANCE / UPDATE



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Handling/Pre									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>M 130746</i> Memo START TIME: <i>10:25</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>10:55</i>	0.00 0.00							<i>1</i> <i>15-5-20</i> <i>38</i>
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<i>1</i> <i>38</i> <i>9-09</i> MAY 20 2015
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo <i>RR 132471 X1</i>	0.00 0.00							<i>1</i> <i>27</i> <i>0-09</i> MAY 20 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 130497***130497***

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Friday, March 13, 2015 11:48:45 AM

Item ID: D3565-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate

Start Date: 3/13/2015 Start Qty: 8.00

8

Cust Item ID:

Required Date: 3/13/2015 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLJ

MAY 21 2015

JHS.S.20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Friday, March 13, 2015 11:48:49 AM

Page 1
✓
1

Work Order ID: 130497

130497

Parent Item: D3565-1

D3565-1

Parent Item Name: Wearplate

Start Date: 3/13/2015

Required Date: 3/13/2015

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev :A New Issue 07-01-16 JLM
IPP rev B revB dwg 07.04.18 ec
IPP Rev:C rev.c as per dwg 08-01-14 DD verified by:
IPP Rev: D QC5 added to step 8 08.12.22 KJ Verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3009-3		Manufactured	No			100	Each	24.0000	3	24			
D3009-3									**				

				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA001		24							
				129883		24							
M304S16GA		Purchased	No			130	sf	483.6926	0.135				

M304S16GA

304/316 Sheet .063

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT019	483.6926	
m131384	200.6926	
m131503	283	

131503

13099412
131855112

Q 15-5-11

⑤ Jm15-3-15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

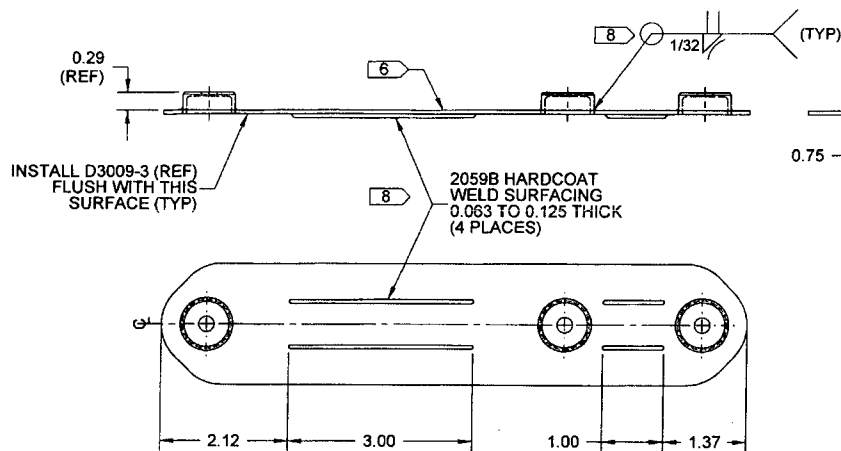
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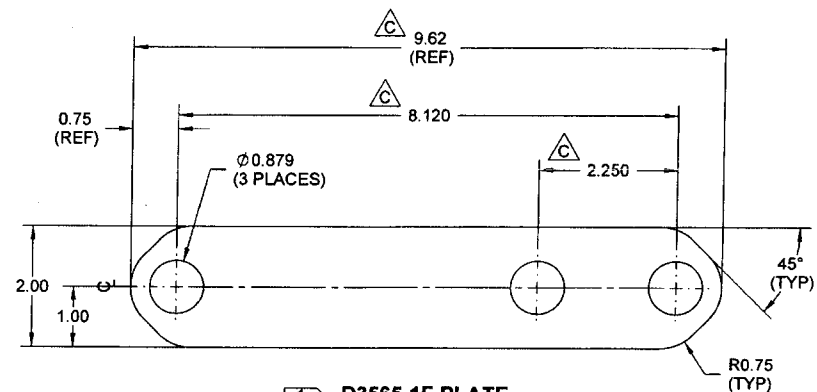
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FAULT CATEGORY

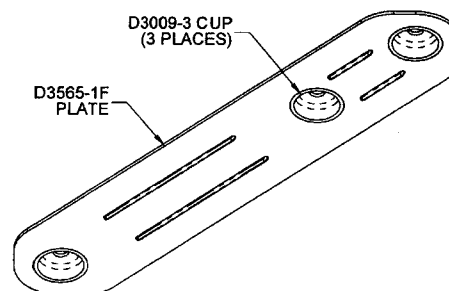
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D3565-1 R44 WEARPLATE



D3565-1F PLATE



D3565-1 PARTS LIST

QTY -1	P/N	DESCRIPTION
X	D3565-1	R44 WEARPLATE
1	D3565-1F	PLATE
3	D3009-3	CUP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK) PER MIL-S-5059 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3565-1" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.38 lbs
- 8) WELD PER DART QSI 004
- 9) PART IS SYMMETRIC ABOUT ϕ

SHOWN
UNCO
SUBJ
WAS
NO. 130497 MWS
1503-13

RELEASED
06-01-11/10

C	WEARPLATE NOW WELDED (C7); 8.120 WAS 8.220, 2.250 WAS 2.300 (D2); ADDED PARTS LIST (B7); UPDATED NOTES (A7)	MB	07.12.14
B	8.220 WAS 8.120; 2.300 WAS 2.250; ADD HOLE DIMS AFTER CUP FORMING	CB	07.03.12
A	NEW ISSUE	CB	07.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	CB		
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	07.12.14		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3565** REV. C
TITLE **R44 WEARPLATE** SCALE 1:2

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